

Date: Friday, 22/08/2008 2:02:20 PM
User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: 1/4 TURN FASTNER RAIL (BLACK)
Job Number	: 41592 -3	Part Number	: D103858B
Estimate Number	: 10096	Drawing Number	: D1038
P.O. Number	:	Project Number	: N/A
This Issue	: 22/08/2008 S.O. No. :	Drawing Revision	: B
Prsht Rev.	: NC	Material	:
First Issue	: 1/1 Type : MACHINED PARTS	Due Date	: 16/09/2008
Previous Run	: 38022	Qty:	100 Um: Each
Written By	:		
Checked & Approved By	: JLD 08.8.22		
Comment	: Est: E 03.05.02 Reformat; Added label KJ/RF Est Rev:F 06-08-16 Updated Packaging Procedures JLM		

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



JLD 08.09.06



Comment: DOCUMENT CONTROL
Create white labels and bag them

2.0 D2023 Extrusion, Fastener Rail



Comment: Qty.: 1.9030 f(s)/Unit Total: 190.3000 f(s)
Extrusion, Fastener Rail

B21907

J.F. 08/09/07

(110)

3.0 BAND SAW BAND SAW



Comment: BAND SAW
Cut extrusion D2023 to length 21.81" (+0.06/-0.00)

J.F. 08/09/08

(110)

4.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1
1-Machine as per Folio and Dwg D1038-58

DJP 08/09/09

(110)

5.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

DJP 08/09/09

(110)

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 22/08/2008 2:02:20 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 1/4 TURN FASTNER RAIL (BLACK)

Job Number: 41592

Part Number: D103858B

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC8

SECOND CHECK



Comment: SECOND CHECK

5.1 08/09/12

7.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
Debur

08/09/15 (110)

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/09/16 (110) counter

9.0

OUTSIDE SERV.30

OUTSIDE SERVICES-MACH



Comment: Sub-Contracting OUTSIDE SERVICES
Issue P/O: 7124
Black Anodize as per Dwg D1038

08/09/16 (110)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1
Receive & Inspect For Transit Damage

08/09/15 (100)

11.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: Inspect Anodize. Place in foam to protect anodize

08/09/25

110

12.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1
1-Stake .050 stainless steel wire per Dwg D1038-58 using DT8389
Batch: 1104298
2-Grind wire flush and deburr
3-Clean


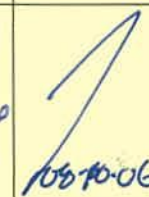

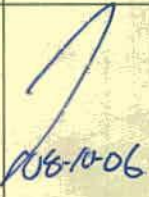
PTO

08/09/30

110

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D1038-58B PAR #: N/A Fault Category: Prod / FAB. ASSY mod & Smt NCR: (Yes) No DQA: D Date: 08/10/06
 Resolution: Scrap Disposition: Scrap QA: N/C Closed: D Date: 08/10/06

NCR: 41592		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
03/10/06	12	1 pin was to thin + broke For Deburred too much on these ends. RC: Process		Scrap & destroy use a S.S. brush to deburr.	SB 03/10/06			

NOTE: Date & initial all entries

Date: Friday, 22/08/2008 2:02:20 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 1/4 TURN FASTNER RAIL (BLACK)

Job Number: 41592

Part Number: D103858B

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SP 08/10/06

(92)

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

1-Pack each fastener rail into a cardboard tube

2-Roll Part in foam .

3-Install red cap at each end and secure with tape.

4-Apply white labels to cardboard tubes

5-Identify and Stock

Location: _____

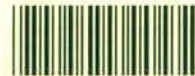
8/10/6

SP (92x)

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/10/08

Job Completion



U 08.10.07

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

08/09/03

DRD-

141

141

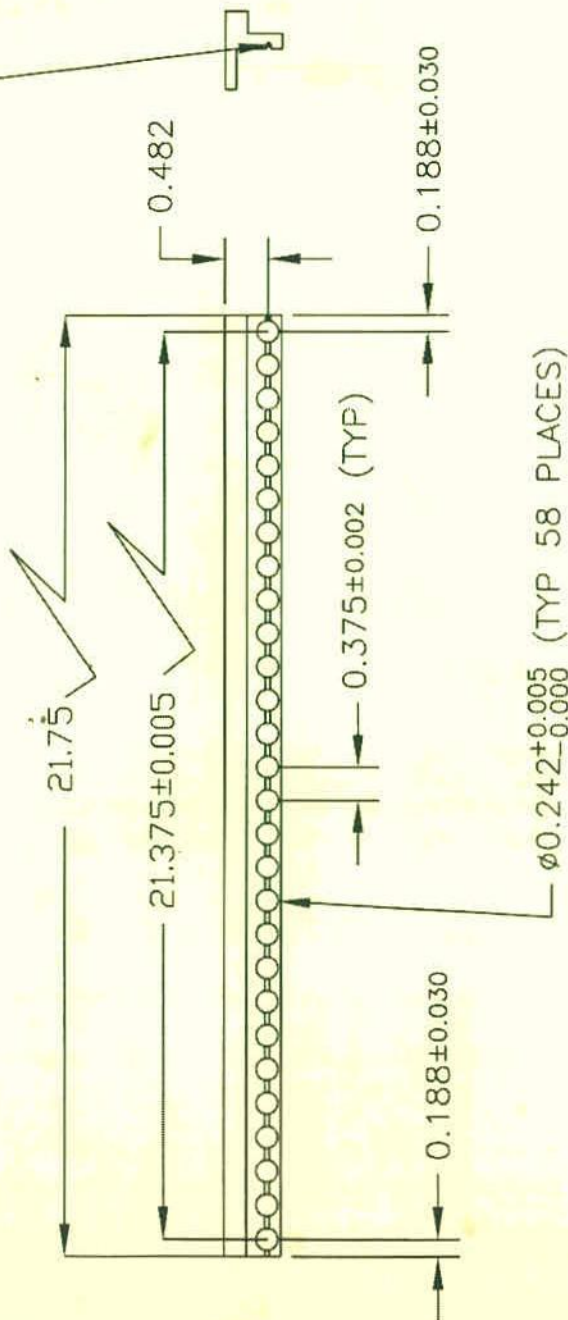
DART

DESIGN H	DRAWN BY H	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED H	APPROVED H	DRAWING NO. D1038	REV. B SHEET 1 OF 1
DATE 05.02.02	TITLE 1/4 TURN FASTENER RAIL	SCALE NTS	
-	91.05.05	NEW ISSUE	
A	04.05.14	UPDATE TOLERANCE	
B	05.02.02	REDRAWN, UPDATE NOTES	

RELEASED

05.03.31 H

STAKE $\phi 0.50$ TYPE 302 STAINLESS
STEEL WIRE FULL LENGTH
(REF DART SPEC M302SW.050)



- D1038-58 1/4 TURN FASTENER RAIL
- 1) MAKE FROM D2023 EXTRUSION
 - 2) FINISH: D1038-58 - NONE
D1038-58B - ANODIZE BLACK PER DART QSI 017 4.1.10
 - 3) ALL DIMENSIONS ARE IN INCHES
 - 4) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 41592

Copyright © 2005 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



21 chemin de l'Aviation, Pointe Claire QC H9R 4Z2

Telephone: (514) 429-7777 Fax: (514) 429-5108

Certifié ISO 9001-2000 certified

approuvé NADCAP approved

68350

23-Sep-2008

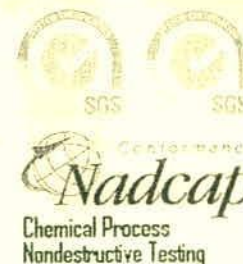
CLIENT / CUSTOMER:

DART AEROSPACE LTD.

1270 ABERDEEN STREET

HAWKESBURY , ONTARIO

K6A 1K7

CERTIFICATE OF COMPLIANCE
CERTIFICAT DE CONFORMITENO. DE COMMANDE: 7174
PURCHASE ORDER/

ITEM	COMMANDE ORDERED	EXPEDIE SHIPPED	PART NUMBER & DESCRIPTION		PART PROCESS & TREATMENT
1	110	110	D103-858-B	B41592	MATL: AL BLACK ANODIZE PER MIL-A-8625F-1 TYPE II CLASS 2 ALL OVER
2	21	21	D3299-3	B41829	MATL: AL BLUE ANODIZE PER MIL-A-86251 TYPE II CLASS 2 ALL OVER

Nous certifions que les pièces énumérées ont été traitées, testées et inspectées selon les spécifications mentionnées.

Les cartes de travail ont été remplies et sont disponibles pour consultation, sur demande.

All parts are processed, tested, and inspected to the requirements of above specifications.

Travel cards have been filled and are available for viewing upon request.

NOTE: Painted Parts will be Fully Solvent Resistant after 7 (seven) Full Days of Air Curing at Ambient Temperatures

NOTE: Les pièces peintes seront complètement résistantes au solvant après 7 (sept) jours complets de séchage à l'air ambiant.

Signature/Signed: _____

Directeur de la Qualité / Q.A. Manager



